109534

Page 1

November-21-13 2:34:07 PM D2274 Accept *N900040100* Item ID: Setup Start Revision ID: Stop Îtem Name: Radius Block **Start Qty: 300.00** *300* Start Date: 11/12/13 **Cust Item ID:** Required Date: 11/21/13 Reg'd Oty: 300.00 *300* **Customer:** Reference: Run Process Plan: MLJ Date: 13-11-27 Tooling: Approvals: Date: Stop QC: Date: SPC(Y/N): Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Reject Reject Accept Insp. Work Center ID Description Code Qty Number Stamp **Run Hours Qty** Draw Nbr **Revision Nbr** D2274 Rev F 100 0.00 44 6 DIP SHEAR *1100* 13-11-26 0.00 Shear Memo blanks 9.00" long +/- 0.030" Shear Note: 1 blank makes 9 pieces 110 0.00 HAAS CNC VERTICAL MACHINING #1 *110* 0.00 HAAS I Memo HAAS CNC vertical machine #1 Machine as per folio D2274 MH 13/11/28 ______ 378 ______ OC2- Inspect parts off machine FAI/FAIB 0.00 120 *120* 0.00 QC Memo Quality Control

DQA: Date:								DART								
						WORK ORDER NON-	WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:							Wo	ork Order up	date only				
Marile Onda						DISPOSITION		, , ,	AGAINST	DEI	PARTMENT	/PROCESS				
Work Orde	er: -					Rework	,		Skid-tube Crosstube	Crosstube		Water Jet	Engineering			
Part N	10					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality			
Paiti	٠٠٠.					Use-as-is	1	Thermoforming Finishing				re/Packaging	Other			
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Cause	İ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector			
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	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	<u></u>	Hardwa		<u></u>	Part Incorre		Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs		1	ion Incomplete/Unqualified	<u></u>	Part Lost/Mi	issing	Weld			
	Cuffs		<u> </u>	Contamination	<u> </u>	-	tions Incomplete/Unclear	—	Part Moved		Wrong Stock Pulled					
	Crushing		<u> </u>	Countersink	\vdash	-1	gned/off center		Positioned V		٦					
Heat Treat		Cut Too Short	\vdash	Mislab			Power Loss/	Surge	Other							
	-	Inspectio	-	Tube	<u> </u>	Drawing	—	Misrea								
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l	<u> </u>	Turning S			<u> </u>	Finish	_	Out of Calibration								
1	Wave/Twist in Tube		Fit/Function		IOut of	Seguence										

109534

Page 2

November-21-1.	3 2:34:07 PN	1			<u> </u>									_
Item ID: Revision ID:	D2274			A	ccept	*N	1900	040	100)* s	etup Sta Sto	IV	S1*	-
Item Name:	Radius Block										510	^ν *Ν	S2*	
Start Date:	11/12/13	Start Qty: 300.00	4	' 3በበ*			Cust Item I	D:						
Required Date:	: 11/21/13	Req'd Qty: 300.00	4	* 300*		•	Customer:							
Reference:														
Approvals:	Process Pla	in:	Date:	. ,	Tooling:		Da	ite:	_	R	tun Sta	1/7	R1*	
→ 1	~QC:		Date:		SPC (Y/N):		Da	nte:			Sto	້ *N	R2*	:
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	<u>+</u> :
130		QC8- Inspect parts - seco	nd check		0.00	١,	1011				1		DAG	1
130 QC Quality Control		Memo			0.00	D.a	13(11)	30		378			08 08	
¹⁴⁰ * 1⊿∩ *		Small Fab			0.00					37	C (HS)	3-12-4	1
Small Fab		Memo			0.00									
Small Fab		TumbleDebu	urr any rough e	dges after tun	ubling									
150		Chemical Conversion Co	oat per QSI005	4.1	0.00					27	\$	201-	13-12	۷
150 HandFinish Hand Finishing		Memo			0.00					<u>T</u>	υ	10 <u>0,</u> 1	<u>, </u>	

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						WORK ORDER NON-	-CC	NFO	RMANCE / UF						AEROSPACE
QA Closed:			Date:								Wo	ork Order up	date only		
Work Orde	r·					DISPOSITION				AGAINST	DEPARTMENT/PROCESS				
vvoik Olde	' · -					Rework	1		Skid-tube	Crosstube	Water Jet				Engineering
Part N	lo.					Scrap			Machining	Small Fab		Prod. Eng. Coor.			Quality
	-	<u> </u>			Use-as-is			noforming	Finishing		Rec/Sto	re/Packaging		Other	
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Cause		Date	Step	Qty	Desci	or non-conformance	ı	ief Eng	i			Date	Verification	า	QC Inspector
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}		Wave/Tw	-		<u> </u>	Fit/Function	_	-	Sequence						

Work Order ID 109534

109534

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November-21-13 2:34:07 PM *N900040100* D2274 Accept Item ID: Setup Start **Revision ID:** Stop Radius Block Item Name: *300* **Start Date:** 11/12/13 **Start Oty:** 300.00 **Cust Item ID:** Required Date: 11/21/13 **Req'd Qty:** 300.00 *300* **Customer:** Reference: Run Start Process Plan: _____ Date: ____ Tooling: Date: Approvals: Stop Date: _____ SPC (Y/N): QC: Date: Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Operation Accept Qty Qty Number Stamp Code Work Center ID Description **Run Hours** 0.00 160 QC7-Inspect Chemical Conversion Coat DAS *160* 27 0.00 QC Memo Quality Control Identify as per dwg & Stock Location: 57008 0.00 170

180

QC21- Final Inspection - Work Order Release

120

Quality Control

170

Packaging

Packaging

Memo

Memo

0.00

0.00

0.00

378x 28 13-12-5

1.2/9. 1/3/2/

DQA:			Date:													
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDATE				AEROSPACE			
QA Closed:			Date:					Work Order update only								
Work Orde	·r·					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS				
Work Orde	-				-	Rework	1		Skid-tube Crosstu	be	1	Water Jet	Engineering			
Part N	lo.					Scrap		Machining Small F			Pro	Quality				
	-					Use-as-is	1	Thermoforming Finishi			Rec/Stor	re/Packaging	Other			
NCR N	NCR No.				Suspected Unapproved]	Large Fab Compos]	Supplier					
Root					Desci	ription of work order update	1	nitial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector			
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	_	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí –	Temperature/Cure			
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	issing	Weld			
]	_	Cuffs	'			Contamination		Instruc	tions Incomplete/Unclear		Part Moved	Γ	Wrong Stock Pulled			
Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	-					
Heat Treat				Cut Too Short		Mislab	eled		Power Loss/	Surge	Other					
		Inspectio	n Strip in	Tube		Drawing		Misrea	d							
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	Wave/Twist in Tube				Fit/Function		Out of	Sequence								

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Picklist Print

November-21-13 2:34:06 PM

Page 1

Work Order ID:

109534

Parent Item:

D2274

Parent Item Name:

Radius Block

Start Date: 11/12/13

Required Date: 11/21/13

Start Qty: 300.00

Required Qty: 300.00

Comments:

IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.125	,	Purchased	No			100	f	68.4200	0.0916	28.92633	DR		
0001 10 But .730 X.123				Location		Loc Qty	Lo	c Code			13-1	1-76	
	•			MAT015		68.42							
				M1:	26043	31.42			33	<u>.4t.</u>			
				M1:	26915	37							

DQA:			Date:												
						WORK ORDER NON-	-CC	NFO	RMANCE / UP				–	_ <u>_</u>	AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only	<u> </u>	
Work Orde	r.					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
WOIK OIGE	' · -				-	Rework			Skid-tube	Crosstube			Water Jet	7 Engi	ineering
Part N	٥.					Scrap			Machining	Small Fab	—			┨ ॅ	Quality
				Use-as-is			moforming	Finishing		Rec/Stor	e/Packaging		Other		
NCR N	ю					Suspected Unapproved				Composite [Supplier		
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Cause		Date	Step	Qty	Desci	or non-conformance	1	ief Eng			}	Date	Verification	Q	C Inspector
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							FA	ULT CA	TEGORY						
Landir						General		1/	Dua			Outside Dim		الم	ure/Forced
	\dashv	Bending			-	Bend	-	1	Program			Over/Under		Set-u	
	—	Centre No	ot Concer	ntric	-	BOM/Route Broken/Damage/Defect	\vdash	Grain Hardwa			_	Part Incorre	}		P erature/Cure
}	-	Cracks	alı /Dinnla	Maria	-	Burrs	\vdash	4	are tion Incomplete/Un	gualified	⊢	Part Lost/Mi	⊢	Weld	erature/ cure
1	_	Crimp/Kir	ıv\ vibbie	y wave		Contamination	\vdash	1	tions Incomplete/U	·	_	Part Moved		_	g Stock Pulled
]	Cuffs Crushing		-	Countersink		4	gned/off center	Ticical	-	Positioned V	L Vrong		o otook i unicu		
	Heat Treat			-	Cut Too Short	\vdash	Mislab	-			Power Loss/		Other		
		Inspection		Tube	-	Drawing		Misrea				1		1	
		Marks/Ch	-			Drill Holes	\vdash	Off-set				-			110 1 5/
		Turning S		ı	-	Finish		4	Calibration						
Wave/Twist in Tube				Fit/Function		4	Sequence								

DART AEROSPACE LTD	Work Order:	109534
Description: Radius Block	Part Number:	D2274
Inspection Dwg: D2274 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.257	+0.005 -0.000	` 1 60	J		NH-04	Caliper		
0.750	+/-0.010	-75\			1			
0.375	+/-0.010	,373	J					
0.125	+/-0.010	1125	<i>J</i>					
0.750	+/-0.010	-757	J					
0.063	+/-0.010	J0S5	J					
			<u> </u>					

Measured by:	M4/M	Audited by:	D.A DA	Prototype Approval:	N/A
Date:	13/11/28	Date:	13/11/30 0.89	Date:	N/A

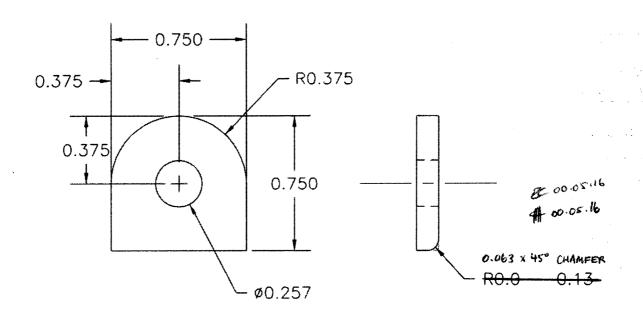
Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	- 4





DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	SED WY	APPROVED	DRAWING NO. REV. F
	N W	4	D2274 SHEET 1 OF 1
DATE			TITLE SCALE
98.0	08.11		RADIUS BLOCK 2:1
A		94.09.29	NEW ISSUE
С		95.07.12	RADIUS ENDS
D		97.03.24	ADD MATERIAL SPECIFICATION
E		97.12.12	ADD FINISH & TOLERANCE QSI
F		98.08.11	RO.0 - 0.13 WAS RO.063 - 0.125





MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK QQ-A-250/11) 0.125 THICK QFINISH: ACID ETCH, ALODINE PER DART QSI 005 4 1 TOLERANCES ARE PER DART QSI 018 ALL DIMENSIONS 125

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED